

**Work Order ID 59438**

Friday, June 04, 2010 10:25:08 AM



Page 1

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Item Name: Spring Spacer

Stop



Start Date: 6/4/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3953	C

100



Hardinge

Memo

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA854 & DWG  
FOLIO REV: C , DWG REV: C , 10/02/07

0.00

20 6 \_\_\_\_\_

DEBURR

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

20 6 \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 59438**

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Page 2

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampMD  
6/06/09

20

0

130



Packaging

Packaging

Identify as per dwg & Stock Location: 103

0.00

Memo

0.00

20 33 10/06/09

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

20 10/06/09  
20 10/06/09

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Friday, June 04, 2010 10:25:12 AM

Page 1

Work Order ID: 59438



Parent Item: D3953-7



Parent Item Name: Spring Spacer

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
MDELRINR0.750						100	f	83.0100	0.05	1.052632			

Delrin Round Bar 0.75"

Location	Loc Oty	Loc Code
MAT	51.1	
114595	51.1	
MAT050	31.91	
112418	0.12	
112480	31.79	

1 foot no toes SA 10 Job lot

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59438
Description: Gas Spring Spacer	Part Number:	D3953-7
Inspection Dwg: D3953      Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

Measured by: ✓  
Date: 10/06/07

Audited by:	MW=
Date:	10/06/07

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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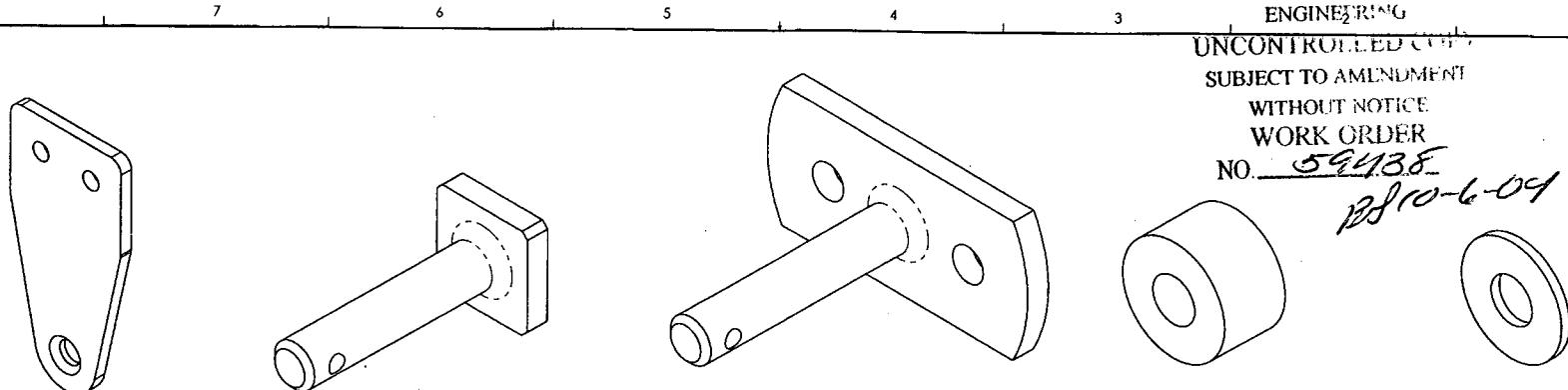
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 59438

*2810-6-09*



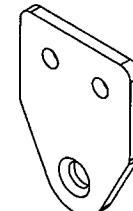
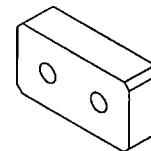
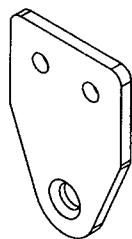
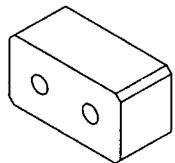
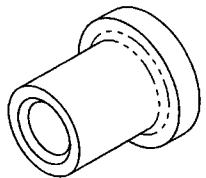
D3953-1 GAS SPRING BRACKET  
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

~~D3953-7 GAS SPRING SPACER~~

D3953-9 GAS SPRING WASHER



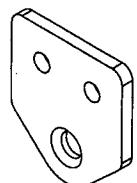
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER  
(FULL LID)

D3953-15 GAS SPRING BRACKET  
(SPLIT LID)

D3953-17 GAS SPRING SPACER  
(SPLIT LID)

D3953-19 GAS SPRING BRACKET  
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET  
(SQUARE BASKET)

C

C	PARTS -19 & -21 ADDED (SHT 1&4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REDUCED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	D3953
CHECKED	99	REV. C	SHEET 1 OF 4
MFG. APPR.	B	TITLE	GAS SPRING LID COMPONENTS
APPROVED	H	SCALE	NTS
DE APPR.	H	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.29		

RELEASED  
2010-02-26

8 7 6 5 4 3 2 1

C

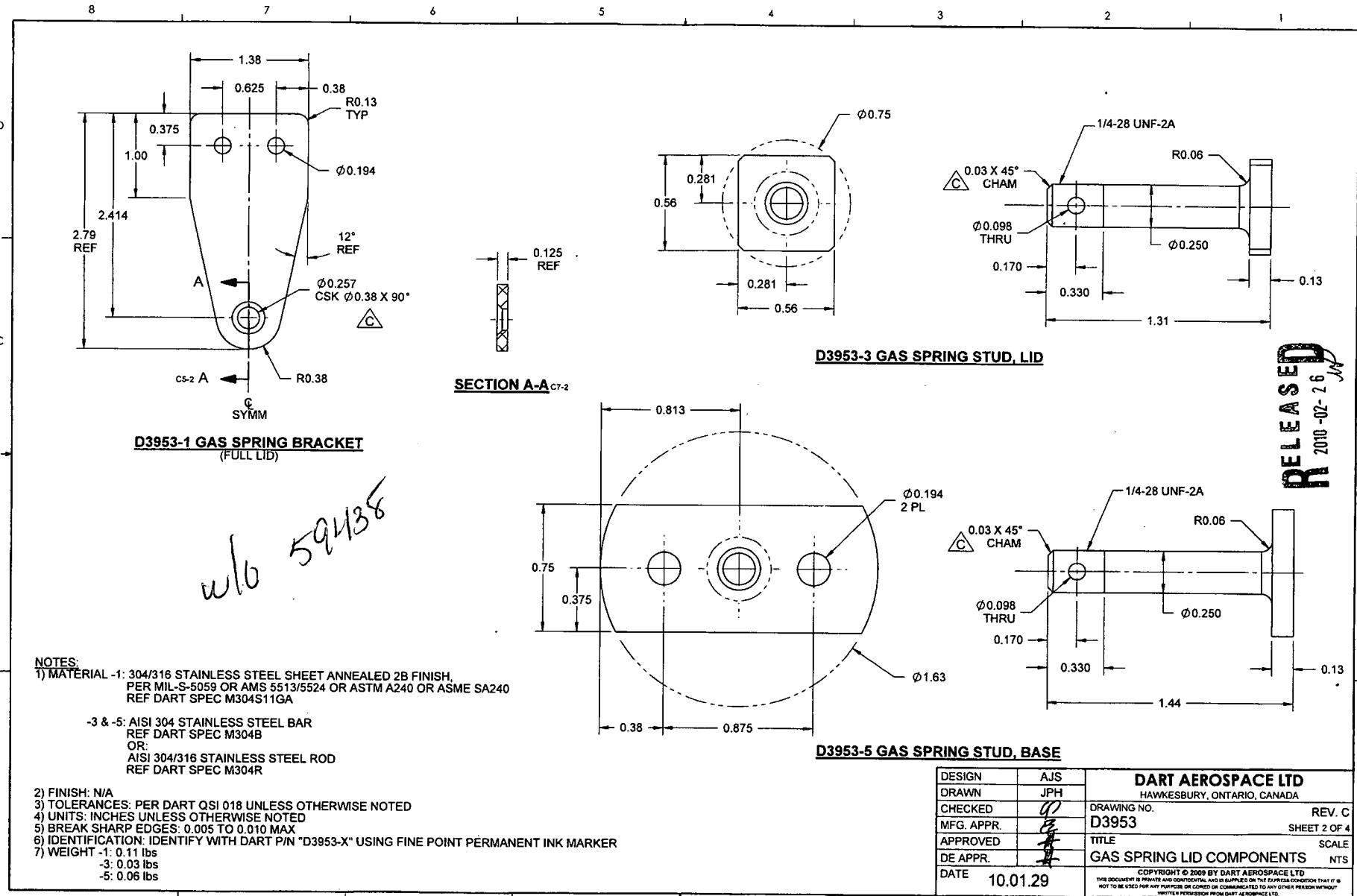
A

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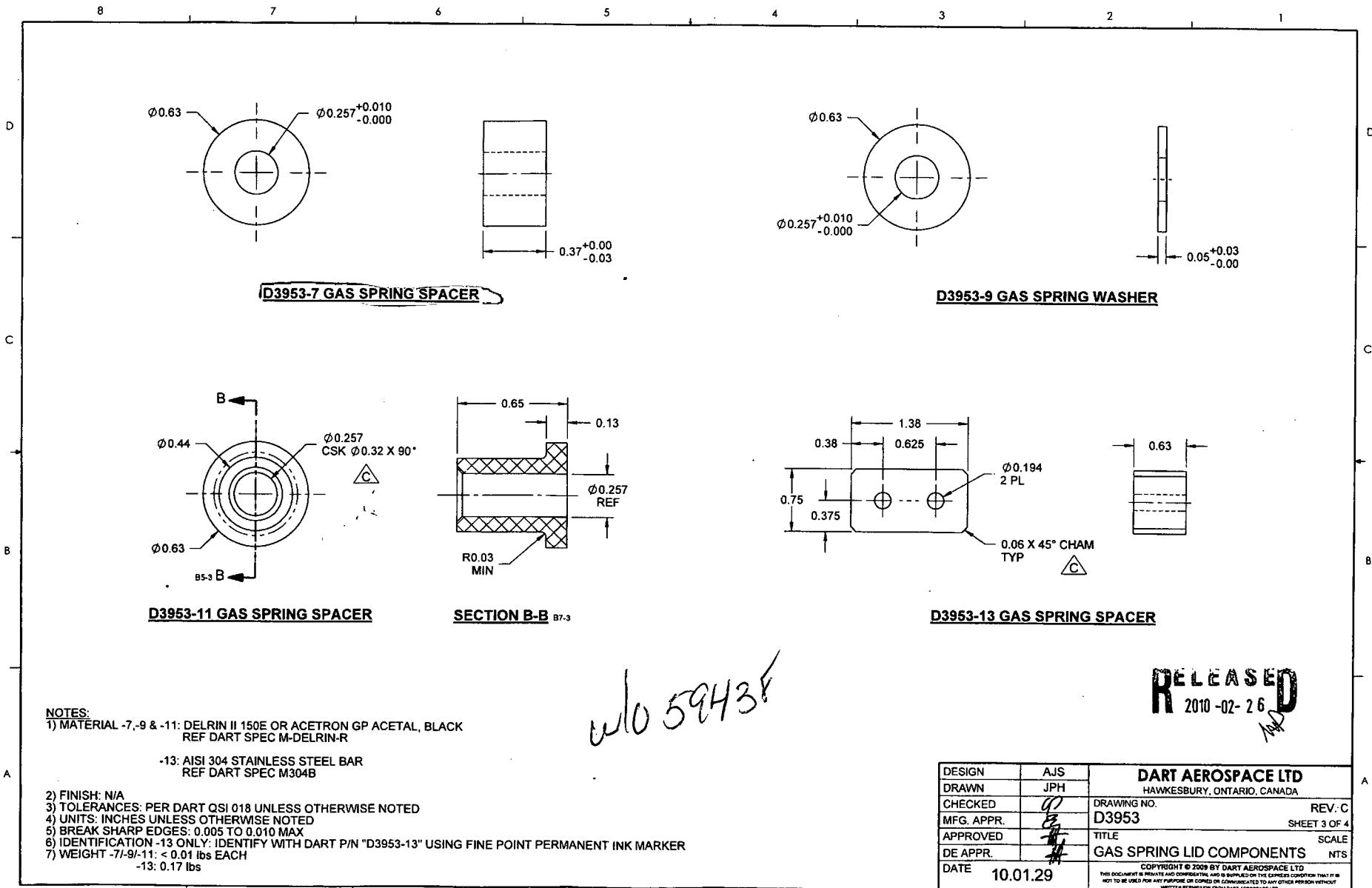
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKSLEY, ONTARIO, CANADA	
CHECKED	GD	DRAWING NO.	REV. C
MFG. APPR.	GD	D3953	SHEET 2 OF 4
APPROVED	GD	TITLE	SCALE
DE APPR.	GD	GAS SPRING LID COMPONENTS	NTS
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DRAWN	JPH	DRAWING NO. <b>D3953</b>
CHECKED	<i>99</i>	REV.: C
MFG. APPR.	<i>E</i>	SHEET 3 OF 4
APPROVED	<i>H</i>	TITLE
DE APPR.	<i>H</i>	SCALE
DATE	10.01.29	GAS SPRING LID COMPONENTS NTS

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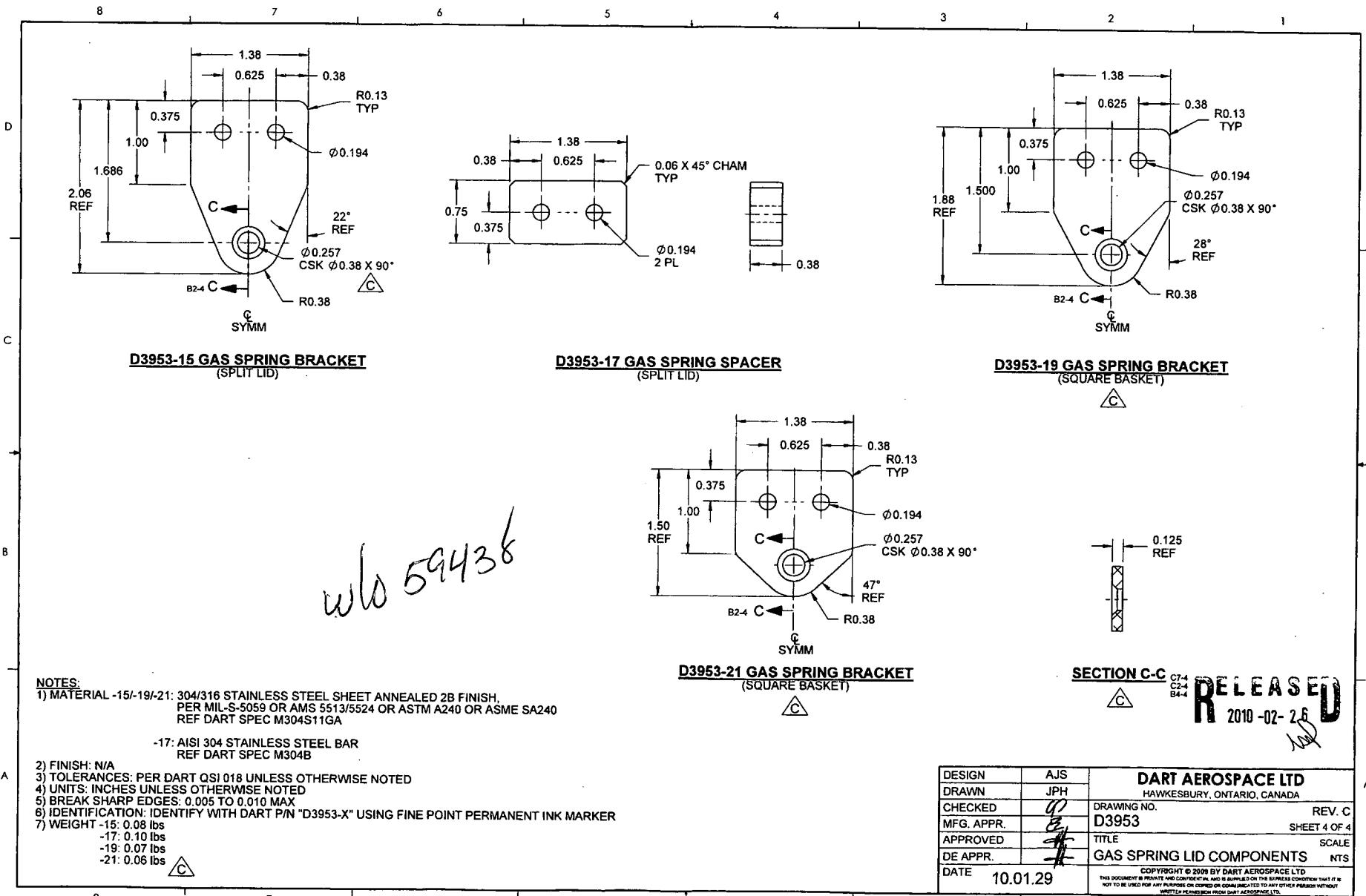
RELEASED  
2010-02-26  
*[Signature]*

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